

Work Order ID 58451 - 1

May 7, 2010 10:08:38 AM



Page 1

Item ID: D3572-041

Revision ID:

Item Name: Guide Assembly

Start Date: 07/05/2010 Start Qty: 10.00

Required Date: 14/05/2010 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *PL*

Date: *10-5-07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572  
2-deburr both ends

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sidorslw*

*EL 10-5-10*

*EL 10-5-10*

*(710)*





# Work Order ID 58451

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Page 2

Item ID: D3572-041

Accept



Setup Start

Revision ID:

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Stop

Start Date: 07/05/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: M112460

0.00

Memo

0.00

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572  
2- grind weld flush at the end of tube only

EL

10-5-11

(16)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulostu

(16)

BE

10-05-11

(16)

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

BE

10-05-11

(16)





**Work Order ID 58451**

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Page 3

Item ID: D3572-041

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Setup Start



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Start Date: 07/05/2010 Start Qty: 10.00



Required Date: 14/05/2010 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

JL 10/05/12

X6 Ø

Memo

190



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

=&gt; JL 10/05/12

X6 Ø

Memo

START TIME: 1:00pm  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 1:30pm

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

G BR 10-5-12

Memo





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Page 4

Item ID: D3572-041

Accept



Setup Start



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Stop



Start Date: 07/05/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

105-12 (6x) SP

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/17 SP  
10-5-17  
(6)





# Picklist Print

May 7, 2010 10:08:43 AM

Page 1

Work Order ID: 58451



Parent Item: D3572-041



Parent Item Name: Guide Assembly

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments:

IPP Rev:A New Issue 07-02-07 JLM

IPP rev B revB dwg EC

IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM

IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

M6061T6T1.000W.188

Purchased No

110

f

121.7490

2.34



6061T6 RD TUBE 1.00 X .188W



EL 10-5-10

## Location

## Loc Qty

## Loc Code

MAT

48

114520

48

MAT016

73.749

113511

26.916

114089

46.833

D3572-3

Manufactured No

130

Each

24.0000

4



Guide



EL 10-5-10

## Location

## Loc Qty

## Loc Code

ST244

24

55725

24

Manufactured No

130

Each

24.0000

1

D3572-5



Bracket



EL 10-5-10

## Location

## Loc Qty

## Loc Code

WA

24

54119

24

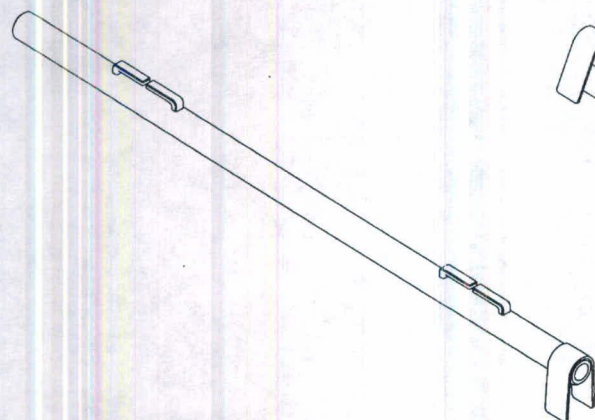
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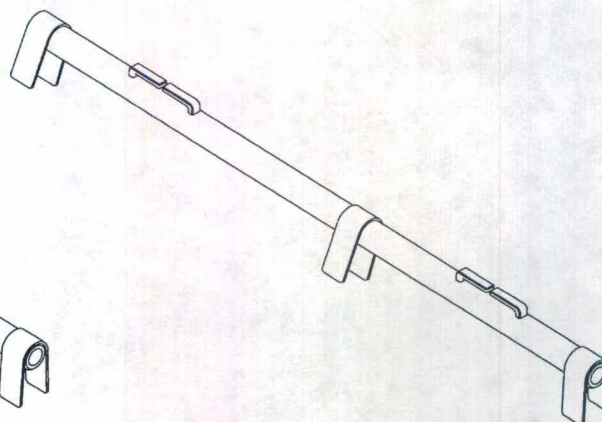


ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

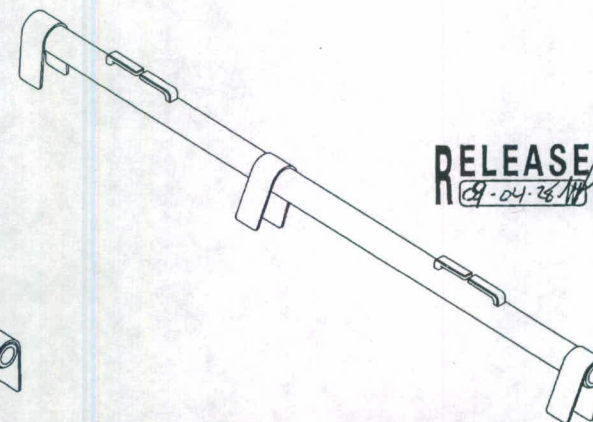
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58451  
BJ 10-507



**D3572-041 GUIDE ASSEMBLY**



**D3572-043 GUIDE ASSEMBLY (UH-1)**



**D3572-044 GUIDE ASSEMBLY (UH-1)**

RELEASED  
09-04-26-17

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS, ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	AJS		
CHECKED	A		
MFG. APPR.	FE		
APPROVED	FE		
DE APPR.	FE		
DATE	09.04.17		

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HAWKESBURY, ONTARIO, CANADA

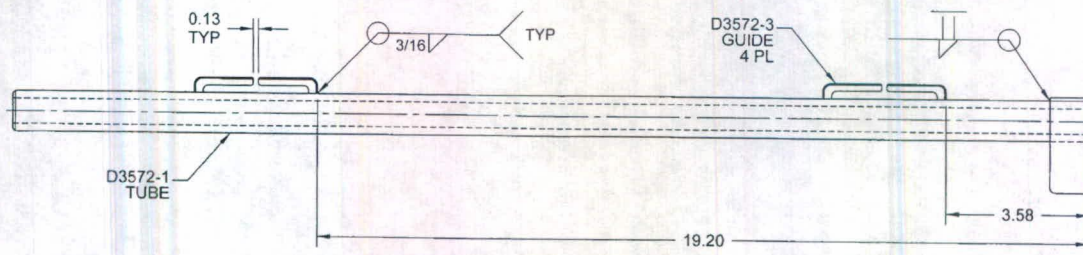
DRAWING NO. **D3572** REV. D  
SHEET 1 OF 4  
TITLE **GUIDE ASSEMBLY** SCALE NTS

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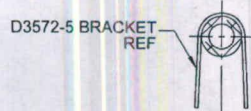




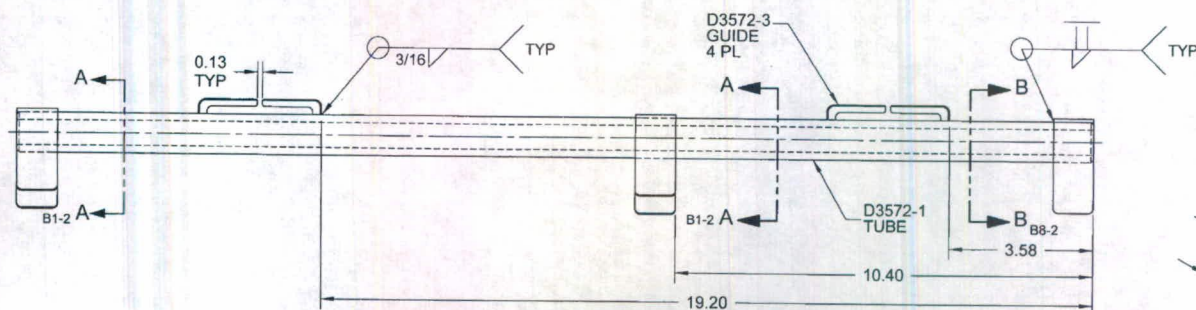
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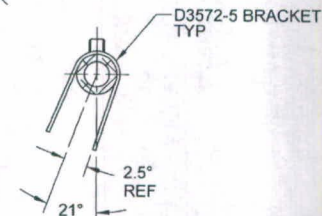
**D3572-041 GUIDE ASSEMBLY**



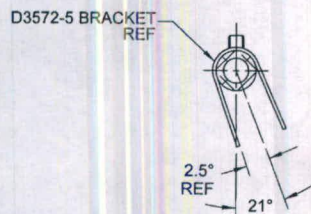
**SECTION B-B C2-2**



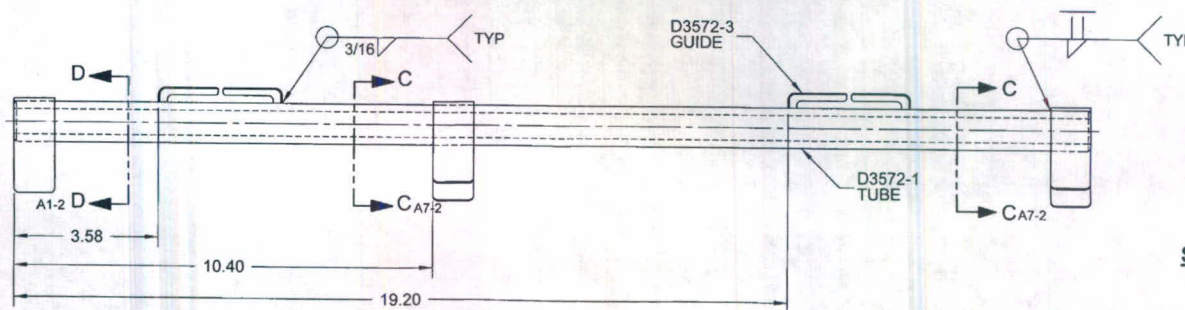
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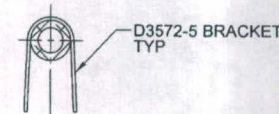
**SECTION A-A C7-2 C4-2 (2 PL)**



**SECTION C-C A2-2 A5-2**



**D3572-044 GUIDE ASSEMBLY**



**SECTION D-D A7-2**

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09.04.17

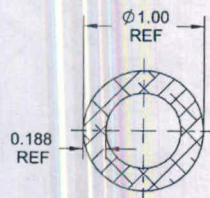
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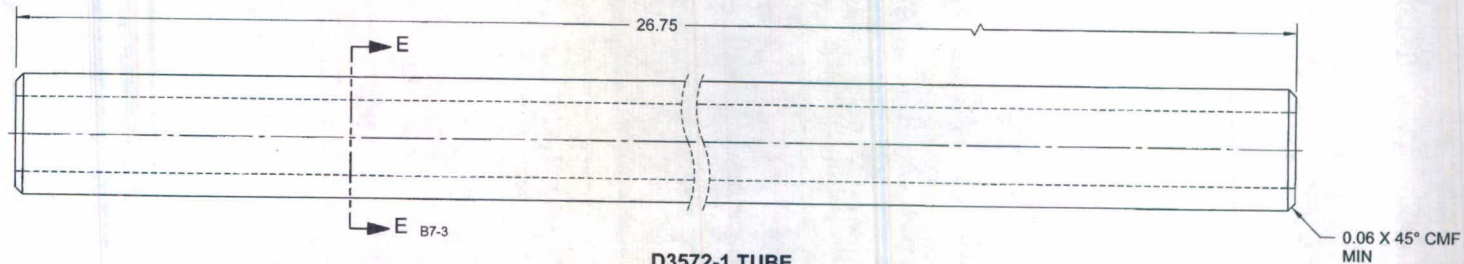
8 7 6 5 4 3 2 1







**SECTION E-E C5-3**



**D3572-1 TUBE**

**D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

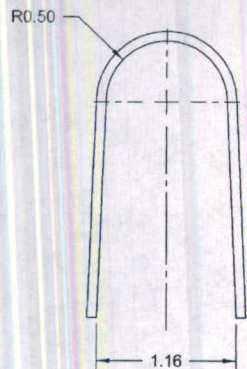
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09/04/17

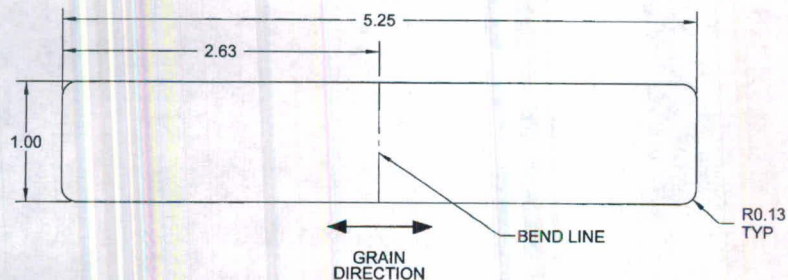
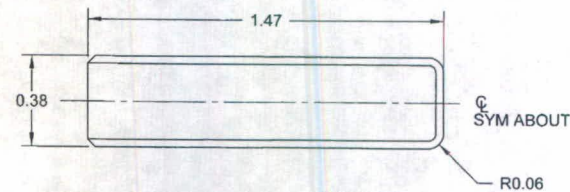
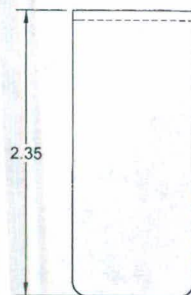
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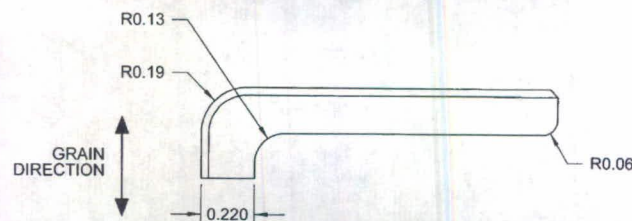




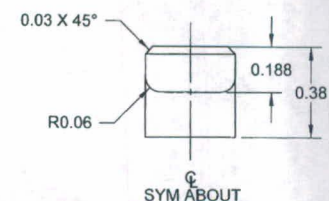
**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



**D3572-5F FLAT PATTERN**



**D3572-3 GUIDE**



**D3572-3 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

**D3572-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

*w/o 58451*

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